

Work Order ID 77088

77088

Page 1

November-25-11 10:34:33 AM

Item ID: D2052 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Bracket
 Start Date: 25/11/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept. Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2052	Rev D								

100 0.00

100

Waterjet

FLOW CNC Waterjet

5052.090

FLOW WATER JET

Memo

1-Cut as per Dwg D2052

Dwg Rev: B

Prog Rev: B

****grain direction along 3.878" ****

2-Deburr if necessary

0.00

12.03.06 (17)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12.03.06 (17)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77088

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

16

Cust Item ID:

16

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120 QC8- Inspect parts - second check

0.00

120

0.00

QC

Memo

Quality Control

130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D2052 using CNC Brake

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10h05 OVEN TEMPERATURE: 320°F FINISH TIME: 10h35								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

17X Ø M-12/03/15

17 Q (DP) 12/03/16

17X Ø M-12/03/16

M115128

W/O:		WORK ORDER CHANGES					
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November-25-11 10:34:33 AM

Page 4

012-03-11

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Picklist Print

November-25-11 10:34:37 AM

Page 1

Work Order ID: 77088

77088

Parent Item: D2052

D2052

Parent Item Name: Mounting Bracket

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP C01.08.21 Added Finishing SM(Issue this IPP with part number D2053)

IPP Rev:D now water jet 07-10-25 DD

IPP Rev:E 08-05-14 chg to revD as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.090

Purchased

No

100

sf

28.9000

0.129

2.172632

**

W 12.03.06

M5052H32S 090

5052-H32 .090 Sheet

Location

Loc Qty

Loc Code

MAT022

14

118641

14

MAT22

14.9

3019

14.9

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Dart Aerospace Ltd

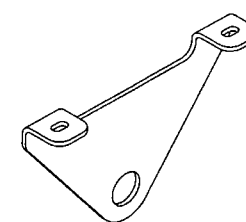
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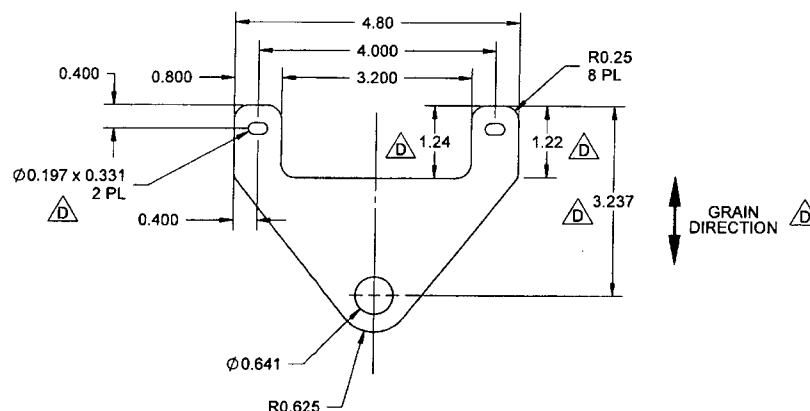
NOTE: Date & initial all entries



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 37-088 M.L.J
11/11/25

D2052 BRACKET



D2052F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR-T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2052" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.08 lbs

RELEASED
08-05-13/11

D	WIDEN SLOT (ZN B7-1); UPDATE FLAT PATTERN DIMENSIONS (ZN B5-1, B6-1); ADD 6061-T6 OPTION (ZN A5-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDTEX (ZN A6-1); ADD IDENTIFICATION (ZN A4-1); ADD WEIGHT (ZN A8-1); ADD GRAIN DIRECTION (ZN B4-1); REASON: PRODUCT IMPROVEMENT (REF PAR 08-012)	PH	08.04.28
C	ADD FLAT PATTERN	RF	99.04.30
B	ADD SLOT TO FOOT	BW	97.02.21
A	NEW ISSUE	BW	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2052 BRACKET SCALE NTS COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PL		
CHECKED	CP		
MFG. APPR.	MS		
APPROVED	TH		
DE APPR.	TH	REV. D SHEET 1 OF 1	
DATE	08.04.28		

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